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FOREIGN TECHNOLOGY DIV WRIGHT-PATTERSON AFB OHIO  
DEEP COUNTERSUNK HEAD BOLTS (STANDARD PRECISION) SIZES.(U)  
SEP 78

F/G 11/5

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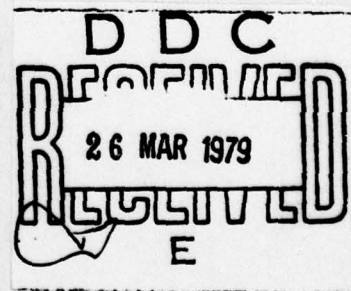
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# FOREIGN TECHNOLOGY DIVISION

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DEEP COUNTERSUNK HEAD BOLTS (STANDARD PRECISION). Sizes



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# EDITED TRANSLATION

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28 September 1978

MICROFICHE NR: *FD-78-C-001318*

DEEP COUNTERSUNK HEAD BOLTS (STANDARD PRECISION).  
SIZES

English pages: 5

Source: USSR State Standard GOST 7787-62

Country of Origin: USSR

Translated by: Marilyn Olachea

Requester: ASD/ENFSS

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DDC	Bull Section <input type="checkbox"/>
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# U. S. BOARD ON GEOGRAPHIC NAMES transliteration SYSTEM

Block	Italic	Transliteration	Block	Italic	Transliteration
А а	<i>А а</i>	A, a	Р р	<i>Р р</i>	R, r
Б б	<i>Б б</i>	B, b	С с	<i>С с</i>	S, s
В в	<i>В в</i>	V, v	Т т	<i>Т т</i>	T, t
Г г	<i>Г г</i>	G, g	У у	<i>У у</i>	U, u
Д д	<i>Д д</i>	D, d	Ф ф	<i>Ф ф</i>	F, f
Е е	<i>Е е</i>	Ye, ye; E, e*	Х х	<i>Х х</i>	Kh, kh
Ж ж	<i>Ж ж</i>	Zh, zh	Ц ц	<i>Ц ц</i>	Ts, ts
З э	<i>З э</i>	Z, z	Ч ч	<i>Ч ч</i>	Ch, ch
И и	<i>И и</i>	I, i	Ш ш	<i>Ш ш</i>	Sh, sh
Й й	<i>Й й</i>	Y, y	Щ щ	<i>Щ щ</i>	Shch, shch
К к	<i>К к</i>	K, k	Ъ ъ	<i>Ъ ъ</i>	"
Л л	<i>Л л</i>	L, l	Ы ы	<i>Ы ы</i>	Y, y
М м	<i>М м</i>	M, m	Ь ь	<i>Ь ь</i>	'
Н н	<i>Н н</i>	N, n	Э э	<i>Э э</i>	E, e
О о	<i>О о</i>	O, o	Ю ю	<i>Ю ю</i>	Yu, yu
П п	<i>П п</i>	P, p	Я я	<i>Я я</i>	Ya, ya

\*ye initially, after vowels, and after ъ, ы; e elsewhere.  
When written as ё in Russian, transliterate as yë or ë.

## RUSSIAN AND ENGLISH TRIGONOMETRIC FUNCTIONS

Russian	English	Russian	English	Russian	English
sin	sin	sh	sinh	arc sh	sinh <sup>-1</sup>
cos	cos	ch	cosh	arc ch	cosh <sup>-1</sup>
tg	tan	th	tanh	arc th	tanh <sup>-1</sup>
ctg	cot	cth	coth	arc cth	coth <sup>-1</sup>
sec	sec	sch	sech	arc sch	sech <sup>-1</sup>
cosec	csc	csch	csch	arc csch	csch <sup>-1</sup>

Russian	English
rot	curl
lg	log



1427

USSR State Standard

GOST 77877-62, replaces GOST 7787-57

Deep Countersunk Head Bolts (Standard precision). Sizes

Approved by the Committee on Standards, Measures, and Measuring Instruments under the auspices of the Council of Ministers USSR 27/3 1962. Date of introduction established at 1/1 1964

Nonobservance of standard punishable by law.

1. The dimensions of the bolts must correspond to those indicated on the drawing in Tables 1 and 2 of the present standard.

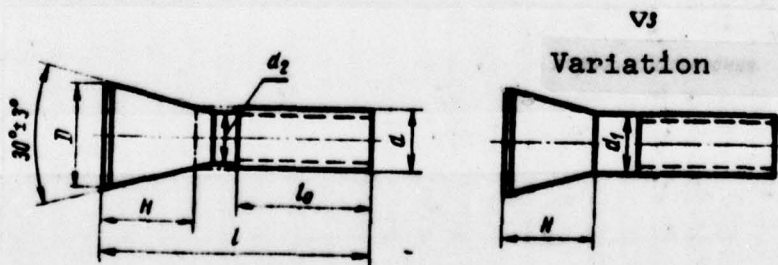


Table 1.

мм		6	8	10	12	16
1	Номинальные диаметры резьбы $d$	1	1,25	1,5	1,75	2
2	Шаг резьбы	11	14	17	21	28
3	Диаметр головки $D$	Номи.	$\pm 0,70$		$\pm 0,84$	
		Доп. откл.				
4	Высота головки $H$	Номи.	9	11	13	16
		Доп. откл.	$\pm 0,9$	$\pm 1,1$		$\pm 1,3$
5	Диаметр стержня $d_1$	Номи.	6	8	10	12
		Доп. откл.	$-0,48$	$-0,58$	$-0,70$	
6	Допускаемое смещение оси головки	0,4		0,5		0,7

Key: 1 - Nominal diameter of thread  $d$ , 2 - screw pitch, 3 - Diameter of head  $D$ , 4 - Height of head  $H$ , 5 - Diameter of shaft  $d_1$ , 6 - Permissible shift in axis of head, 7 - Nominal. 8 - Permissible deviation.

Table 2.

		мм					
1 Номинальные диаметры резьбы d		6	8	10	12	16	
2 Длина болта l	3 Допускаемое отклонение на l при диаметрах болтов	4 Длина резьбы l <sub>0</sub> , включая сверл резьбы					
	5 от 6 до 12 16						
40	±0,8	—	18	—	—	—	—
45			18	22	—	—	—
50			18	22	26	—	—
55			18	22	26	—	—
60			18	22	26	30	—
70	±1,5	±1,8	18	22	26	30	—
80			—	22	26	30	38
90			—	22	26	30	38
100			—	22	26	30	38
110			—	22	26	30	38
120	±1,8	±2,0	—	—	26	30	38
130			—	—	26	30	38
140			—	—	26	30	38
150			—	—	26	30	38
5 Допускаемое отклонение на l <sub>0</sub>		+2,0	+2,5	+3,0	+3,5	+4,0	

Key: 1 - Nominal diameters of thread  $d$ , 2 - Length of bolt  $l$ , 3 - Permissible deviation for  $l$  with bolt diameters of: 3a - from 6 to 12, 4 - Length of thread  $l_0$  including thread taper, 5 - Permissible deviation for  $l_0$ .

Examples of symbols for both of thread diameter  $d = 12$  mm, length  $l = 60$  mm, strength class 3.6, without coating:

Bolt M12 x 60.36 GOST 7787-62.

The same, strength class 4.8 with coating of 01 and thickness of 9  $\mu$ m:



Bolt M12 x 60.48.019 GOST 7787-62.

(Altered edition - "Information Directory of Standards" No 8 1971).

2. Diameter  $d_2$  lies within the limits of the average thread diameter and is established by the producing enterprise.

3. The bolt variation is established by the producing enterprise.

4. Thread - per GOST 9150-59.

5. Thread tolerances - per GOST 9253-59, accuracy class 3.

6. Technical specifications per GOST 1759-70.

(Altered edition - "Information Directory of Standards" No 8 1971).

Replacement



GOST 1759-70 replaces GOST 1759-62.

# APPENDIX

Reference Table for Bolt Weight.

1 Длина болта <i>l</i> в мм	2 Номинальные диаметры резьбы <i>d</i> в мм				
	6	8	10	12	16
	3 Вес 1000 шт. стальных болтов основного исполнения в кг				
40	9,69	—	—	—	—
45	10,57	19,45	—	—	—
50	11,45	21,04	33,68	—	—
55	12,33	22,63	36,18	—	—
60	13,21	24,22	38,68	58,94	—
70	14,98	27,39	43,69	65,83	—
80	—	30,56	48,70	72,72	145,7
90	—	33,73	53,71	79,61	159,0
100	—	36,90	58,72	86,49	172,3
110	—	40,07	63,73	93,38	185,6
120	—	—	68,74	100,2	199,0
130	—	—	73,75	107,1	212,3
140	—	—	78,76	114,0	225,6
150	—	—	83,77	120,9	238,9

Key: 1 - Length of bolt *l* in mm. 2 - Nominal bolt diameters *d* in mm.

3 - Weight of 1000 items of steel bolts of basic variation in kg.

end 1427

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C043 USAMIIA	1	E404 AEDC	1
C509 BALLISTIC RES LABS	1	E408 AFWL	1
C510 AIR MOBILITY R&D	1	E410 ADTC	1
LAB/FIO		E413 ESD	2
C513 PICATINNY ARSENAL	1	FTD	
C535 AVIATION SYS COMD	1	CCN	1
C591 FSTC	5	ASD/FTD/NIIS	3
C619 MIA REDSTONE	1	NIA/PHS	1
D008 NISC	1	NIIS	2
H300 USAICE (USAREUR)	1		
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